

NEXT-ASA

Dart Aerospace Ltd.

Date: Thursday, 02/04/2009 2:26:16 PM
User: Julie Dawson

Process Sheet

PLEASE (3)

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE
Job Number : 46859
Estimate Number : 10606
P.O. Number :
This Issue : 02/04/2009 S.O. No. :
Prsht Rev. : NC Part Number : D33193
First Issue : / / Type : SMALL /MED FAB Drawing Number : D3319 REV. B
Previous Run : 46178 Project Number : N/A
Written By : Drawing Revision : B
Checked & Approved By : JUL 09 04 02 Material :
Due Date : 17/04/2009 Qty: 10 Um: Each
Comment : Est: A 05.05.12 New issue KJ/JLM
Est Rev:B Now on Waterjet 06-10-03 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S18GA 1010/1025 SHEET .048



Comment: Qty.: 3.4150 sf(s)/Unit Total : 34.1502 sf(s)

1010/1025/A21/6aA SHEET .048" Thick

Batch: 110996

ml 09 04 03

(10)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3319

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

ml 09 04 03

(10)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



ml 09 04 03



(10)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 09 04 06 (10)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

ml 09 04 03

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:26:16 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 46859

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

SB 09/04/06 (10)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 09/04/06 (x10)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: B

Qty Part Number Description Batch

A/R N/A

7560 Hardcoat Rod

Batch M109560

EL 9-4-8 (x10)

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/04/08 (x10)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/08 (KCC)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

12:15

OVEN TEMPERATURE:

320°

FINISH TIME:

12:45

FL 09/04/09 (10)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 09-04-9 (10)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 2:26:16 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 46859

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description :

P/N: D3319-3, B/N: BXXXXX
For Product Eligibility see PDA05-18
and Stock
Location: 447

9/4/13

16 SD

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/13

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-04-13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By.	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46859	
Description: Wearplate		Part Number: D3319-3	
Inspection Dwg: D3319 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

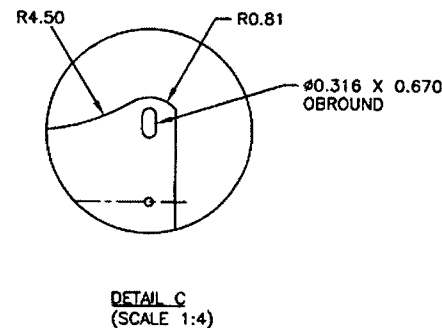
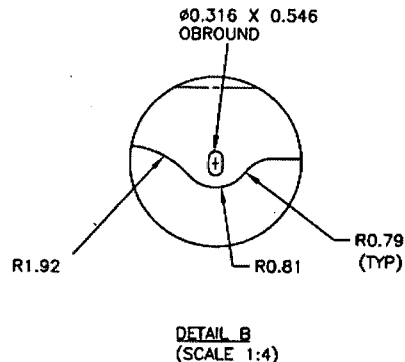
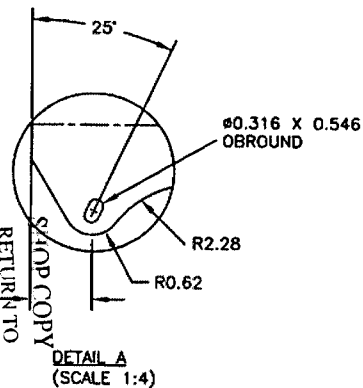
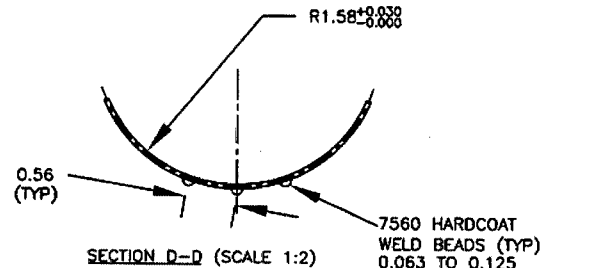
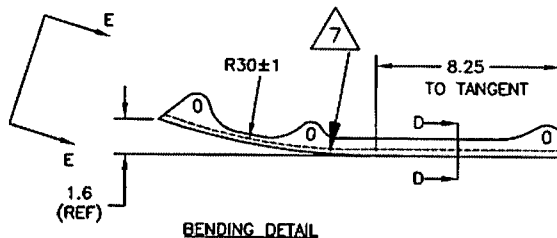
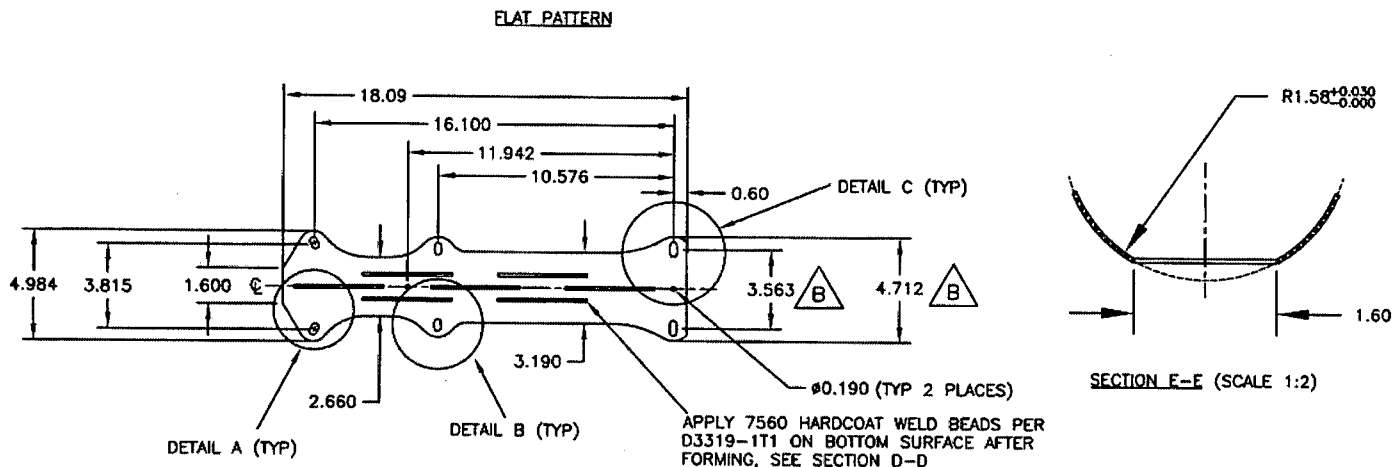
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
75.52	+/-0.030	75.52	✓		M.T	
74.420	+/-0.010	74.420	✓		M.T	
62.770	+/-0.010	62.770	✓		M.T	
52.890	+/-0.010	52.890	✓		M.T	
30.790	+/-0.010	30.790	✓		M.T	
8.690	+/-0.010	8.690	✓		M.T	
0.60	+/-0.030	0.60	✓		VERN	
2.690	+/-0.010	2.695	✓		VERN	
2.940	+/-0.010	2.947	✓		VERN	
3.527	+/-0.010	3.527	✓		VERN	
4.518	+/-0.010	4.516	✓		VERN	
Ø0.190	+0.005/-0.001	0.190	✓		VERN	
2.940	+/-0.010	2.949	✓		VERN	
2.940	+/-0.010	2.946	✓		VERN	
2.690	+/-0.010	2.698	✓		VERN	
5.063	+/-0.010	5.063	✓		VERN	
6.163	+/-0.010	6.166	✓		VERN	
Ø0.316 x 0.607	+0.006/-0.001 x +/-0.010	316x.608	✓		VERN	
0.048	+/-0.010	0.048	✓		VERN	

Measured by: ml, ml	Audited by: S	Prototype Approval:	N/A
Date: 09.04.03	Date: 09/04/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	BE

DART



D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:

"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	DRAWN BY	DART AEROSPACE LTD
P11	011	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
05.06.06	05.06.06	D3319
DATE	TITLE	REV. B
05.06.06	WEARPLATE	SHEET 1 OF 5
A	04.09.24	NEW ISSUE
B	05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7
		SCALE 1:8

RELEASED
05-09-30

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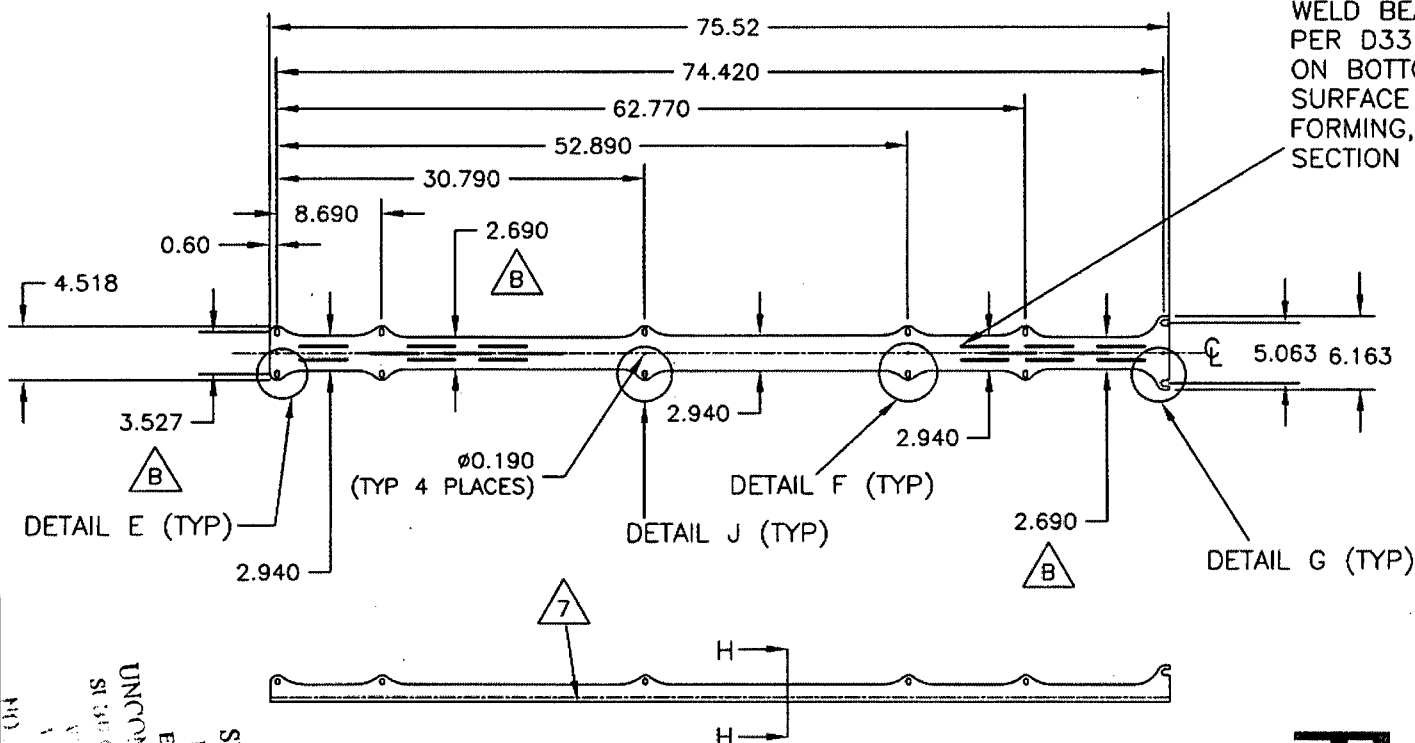
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DART

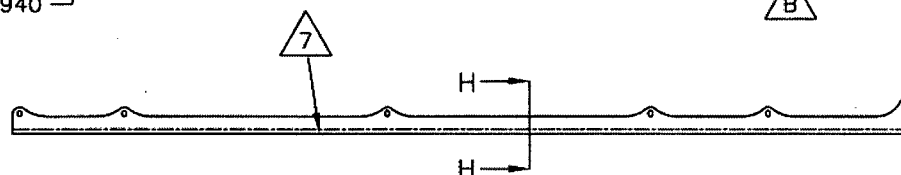
DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>PH</i>	APPROVED <i>PH</i>	HAWKESBURY, ONTARIO, CANADA
DATE 05.06.06	DRAWING NO. D3319	REV. B
	TITLE WEARPLATE	SHEET 2 OF 5
		SCALE 1:15

APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H

FLAT PATTERN



BENDING DETAIL



D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

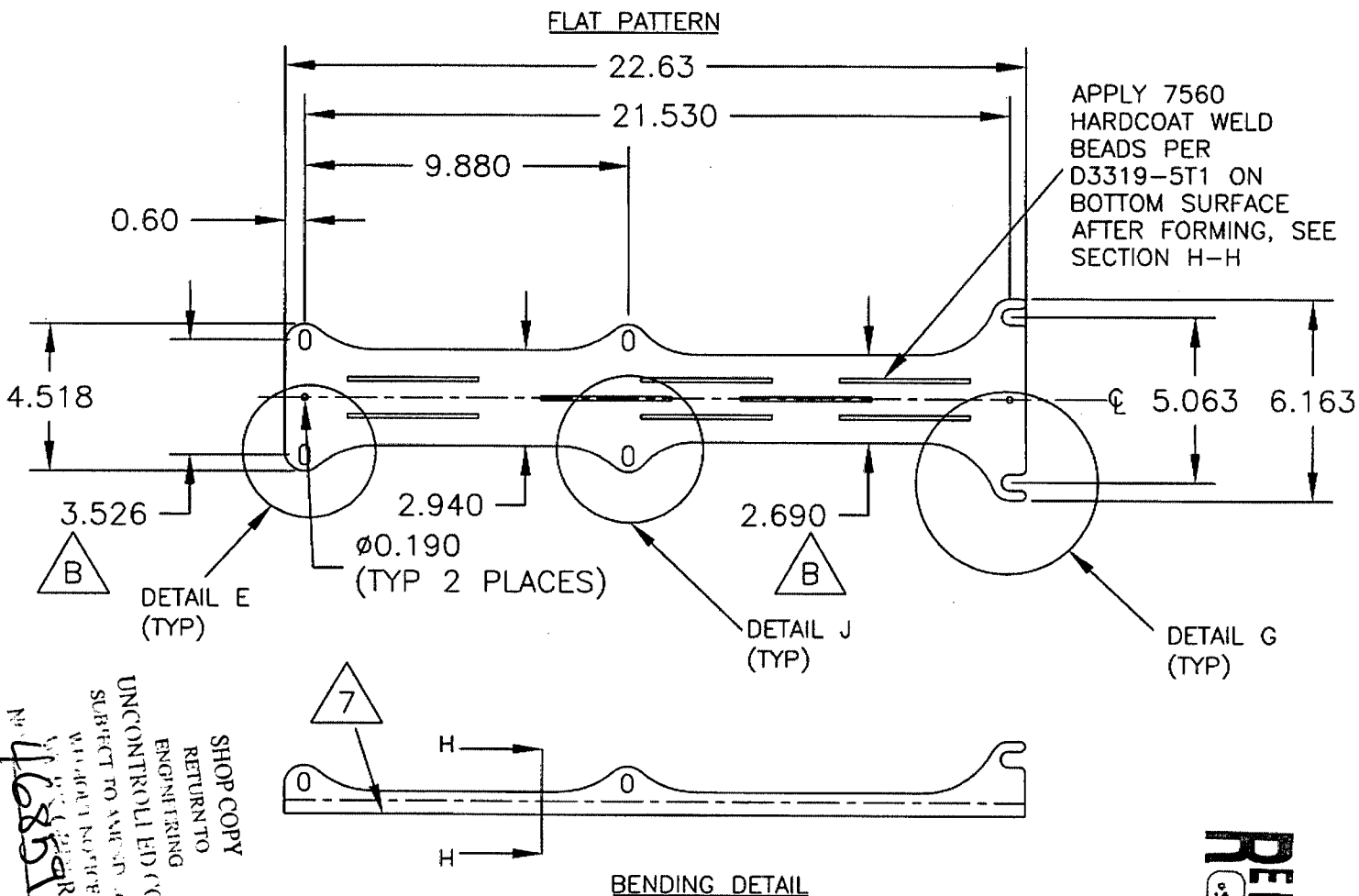
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15-07-30

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DATE 11/08/09

DART

DESIGN	D311	DRAWN BY	GH	DART AEROSPACE LTD	
CHECKED	GH	APPROVED	GH	HAMKESBURY, ONTARIO, CANADA	
DATE	05.06.06	TITLE	D3319	REV. B	
		WEARPLATE		SHEET 3 OF 5	
				SCALE	1:5

RELEASED
05-07-30-100

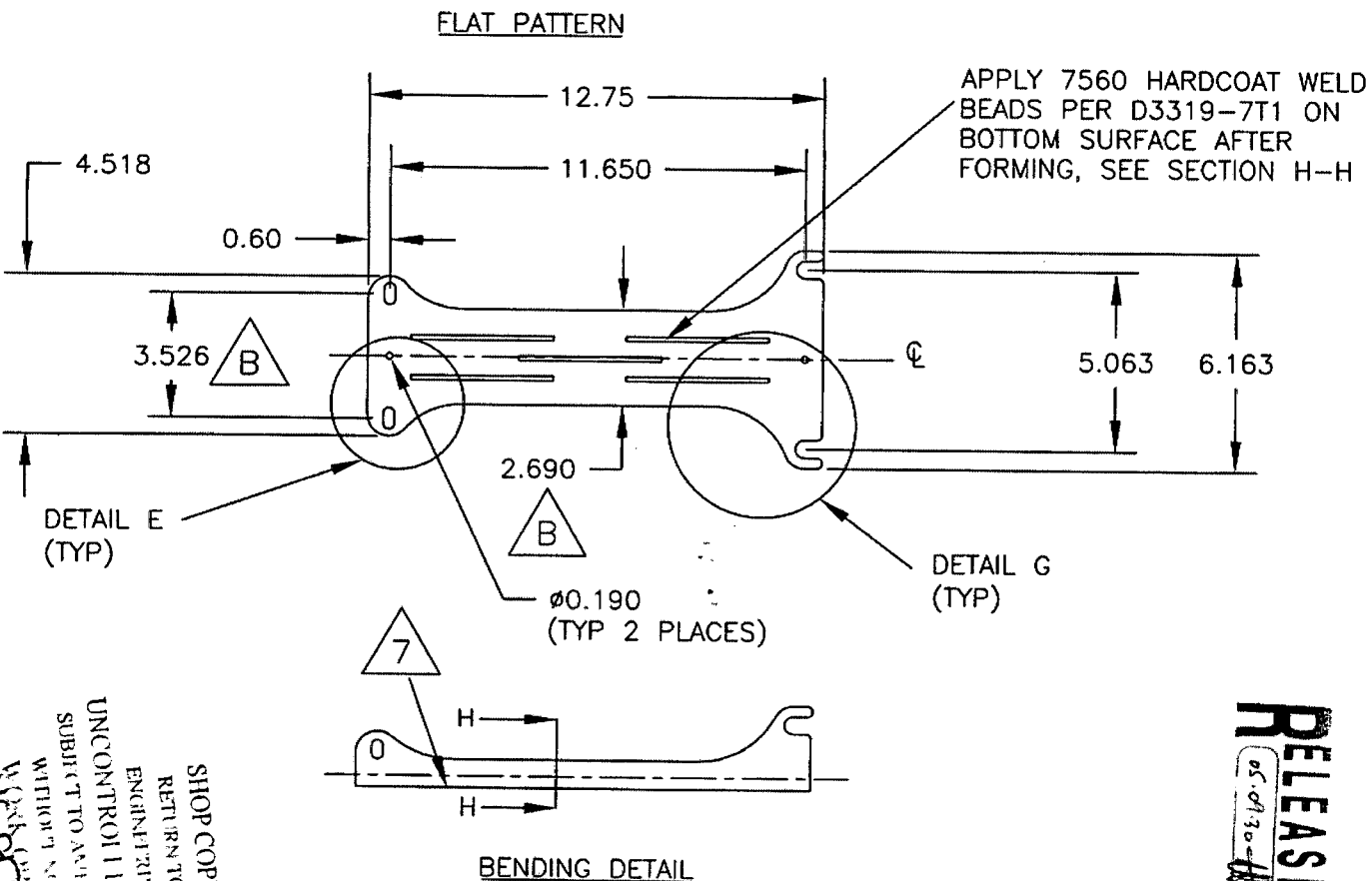


D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DART

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	D3319	REV. B
				SHEET 4 OF 5
				SCALE
				1:5

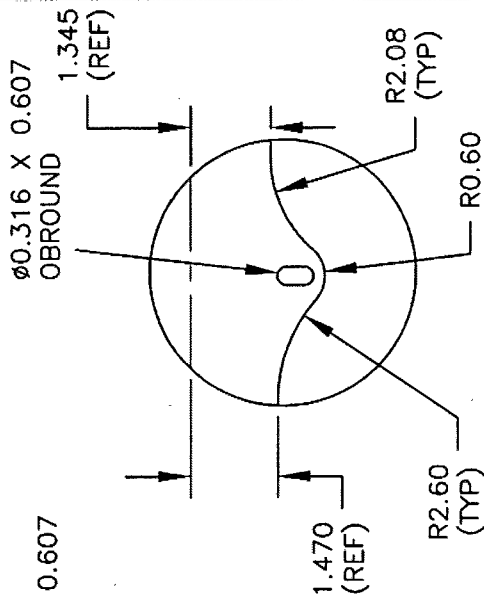
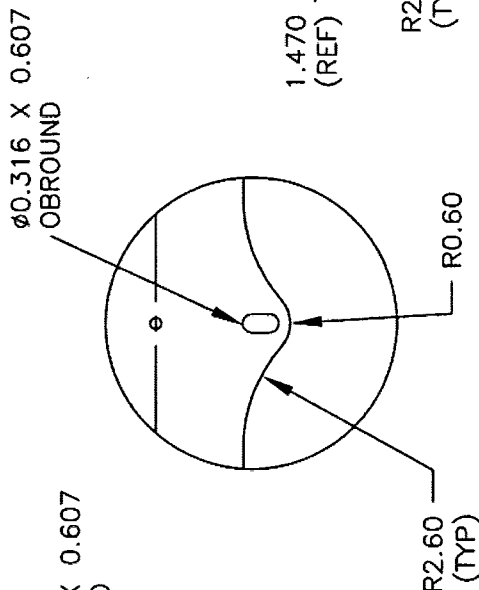
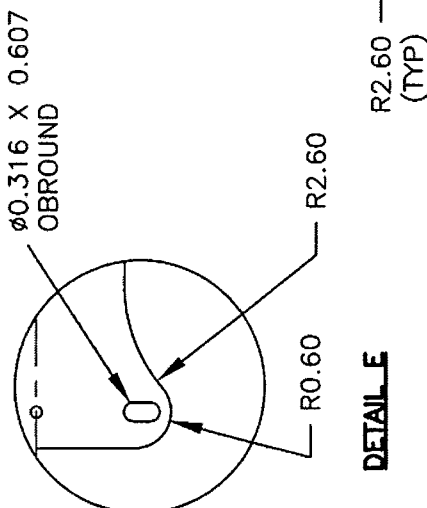
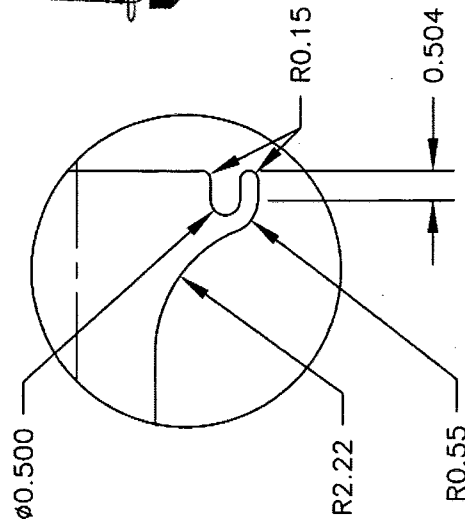
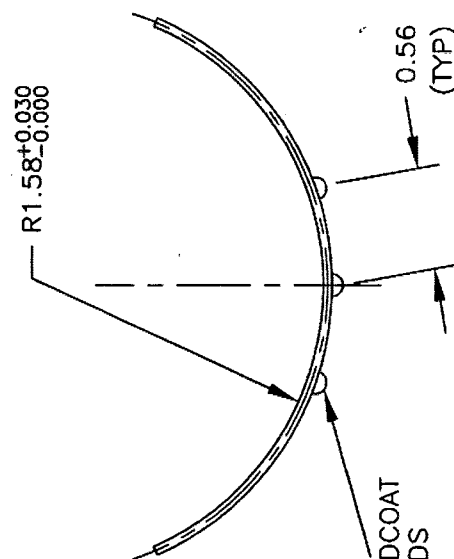
RELEASED
05.07.30-11**D3319-7 WEARPLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,
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DART

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06	TITLE WEARPLATE		SCALE 1:3

RELEASED
05-09-30**DETAIL J****DETAIL F****DETAIL E****DETAIL G****SECTION H-H
(SCALE 1:1)**

7560 HARDCOAT
WELD BEADS
(TYP)
0.063 TO 0.125
HIGH

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